

Work Order ID 75206-2

October-18-11 4:11:08 PM

Need to ship Oct 24

\*75206\*

Rush ASAP!!

Page 1

Item ID: D3199-3

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Bracket, Fwd LH

*Split AD*

Start Date: 18/10/2011 Start Qty: 90.00

\*90\*

Required Date: 04/11/2011 Req'd Qty: 90.00

\*90\*

Reference:

Approvals: Process Plan: M.L.S

Date: 11/10/11 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3199	E								
100		0.00							
*100*	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per Dwg D3199 Dwg Rev: <u>F</u> Prog Rev: <u>F</u>								
	Deburr if required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*	Memo	0.00							
QC									
Quality Control									

BB-10-19

W4

BB

BB-10-19

**Work Order ID** 75206

October-18-11 4:11:08 PM

\*75206\*

Page 2

**Item ID:** D3199-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

**Revision ID:**

**Item Name:** Bracket, Fwd LH

Stop \*NS2\*

**Start Date:** 18/10/2011 **Start Qty:** 90.00

\*90\*

Cust Item ID:

**Required Date:** 04/11/2011 **Req'd Qty:** 90.00

\*90\*

Customer:

**Reference:**

**Approvals:** Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

**Sequence ID/  
Work Center ID**

**Operation  
Description**

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

\*120\*

QC

Quality Control

QC8- Inspect parts - second check

0.00

Su10/25

counts

414

Qc P019

130

\*130\*

Brake NC

Brake NC

Bend as per dwg  
Small Fab

0.00

SD 11/10/26

90

140

\*140\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Su10/26

counts

490

Qc P019

->

.

Work Order ID 75206

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\*75206\*

Page 3

Item ID: D3199-3

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Bracket, Fwd LH

Start Date: 18/10/2011 Start Qty: 90.00

\*90\*

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

\*90\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

\*150\*

Powdercoat

Powder Coating

M 118489

Memo

1:40 0.00  
START TIME: 3200F  
OVEN TEMPERATURE:  
FINISH TIME: 2:10

90 X 8 M/L 11/10/26

160

\*160\*

QC

Quality Control

QC3- Inspect Part Finish

0.00

90 BL 11-10-26

170

\*170\*

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

90

11/10/26 88X

88X

Work Order ID 75206

October-18-11 4:11:08 PM

Item ID: D3199-3

Revision ID:

Item Name: Bracket, Fwd LH

Start Date: 18/10/2011 Start Qty: 90.00

Required Date: 04/11/2011 Req'd Qty: 90.00

Reference:

Accept

\*90\*

\*90\*

\*75206\*

Page 4

\*N900040100\*

Setup Start

\*NS1\*

Stop \*NS2\*

Cust Item ID:  
Customer:

Approvals: Process Plan:

QC:

Date:  
Date:

Tooling:

SPC (Y/N):

Date:  
Date:

Run

Start

Stop

\*NR1\*

\*NR2\*

Sequence ID/  
Work Center ID

180

\*180\*

QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Memo

0.00

11/10/24  
MK  
11-10-26

**Picklist Print**

October-18-11 4:11:12 PM

Page 1

Work Order ID: 75206

**\*75206\***  
**\*D3199-3\***

Parent Item: D3199-3

Parent Item Name: Bracket, Fwd LH

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 90.00

Required Qty: 90.00

**Comments:** IPP RevA: RevC-prelim DD verified by:EC  
11.03.31 as per een 11-531 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	137.0795	0.1673	15.84947			

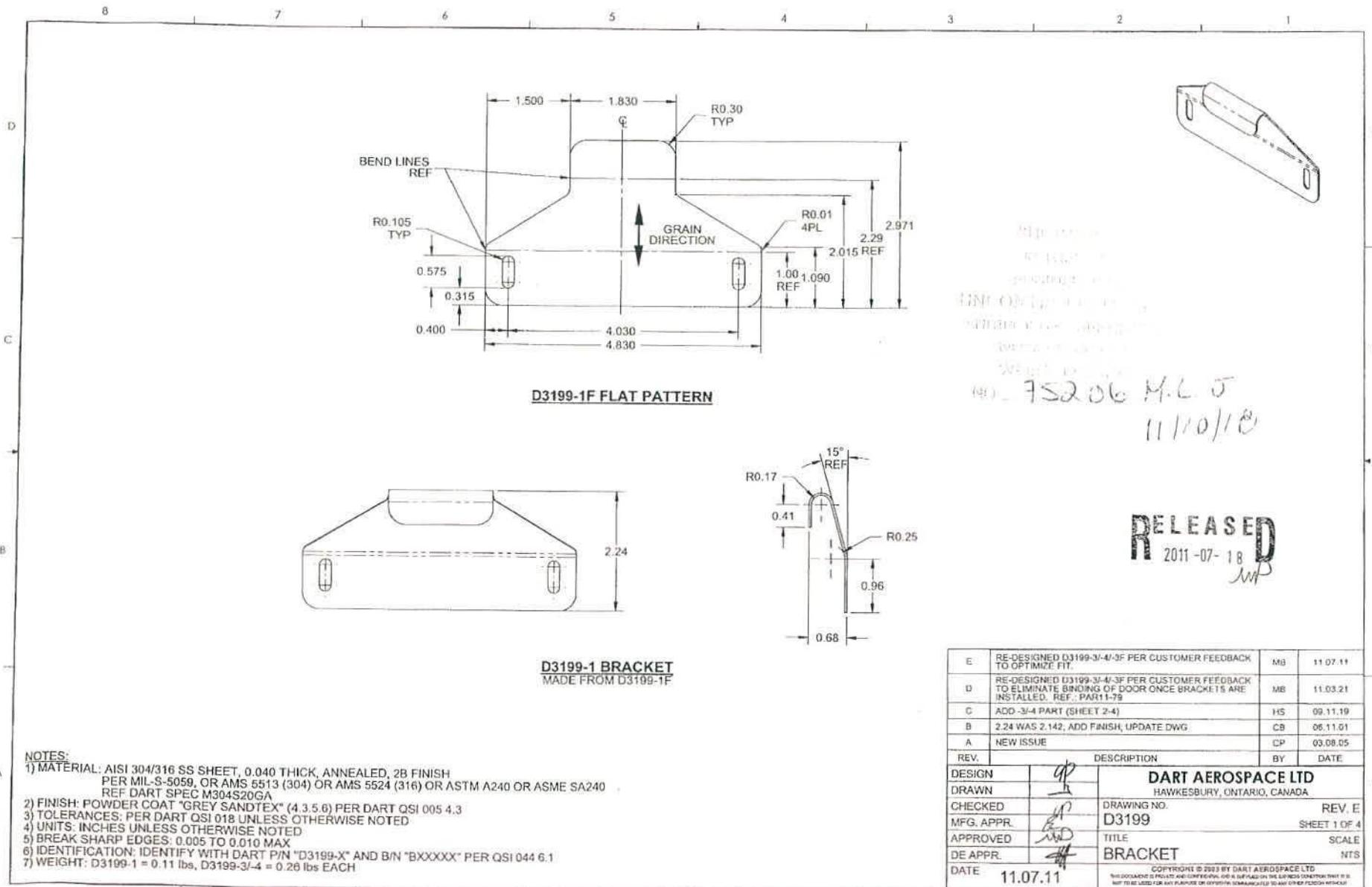
**\*M304S20GA\***

304/316 .040 Sheet

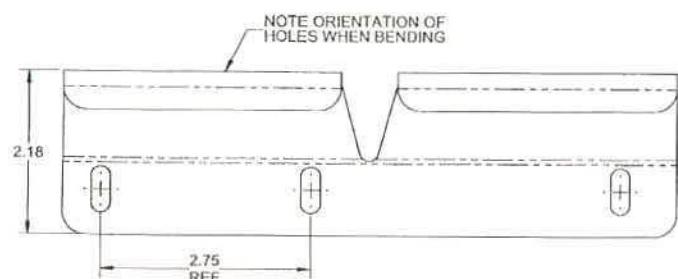
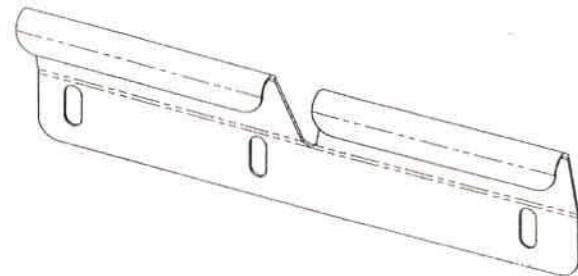
**\*\***

10-10-19

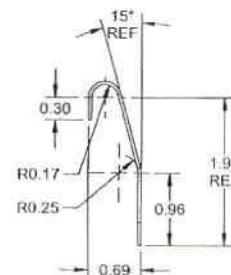
Location	Loc Qty	Loc Code
MAT020	137.0795	
116623	0.2	
117550	8.363	
117933	43.3442	117933
118400	25.6723	
118964	59.5	



752 bb



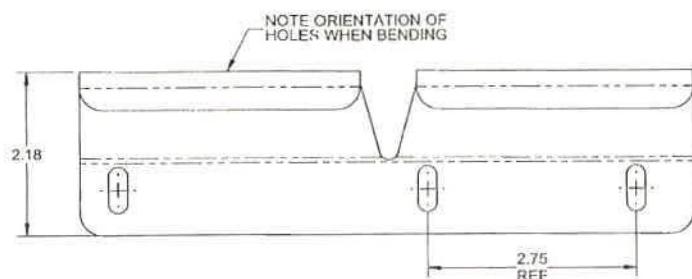
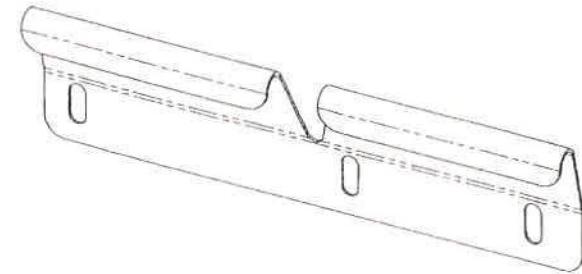
D3199-3 BRACKET  
MADE FROM D3199-3F



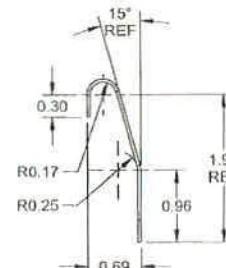
RELEASED  
2011-07-18  
MP

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. E
MFG. APPR.		D3199 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		BRACKET NTS
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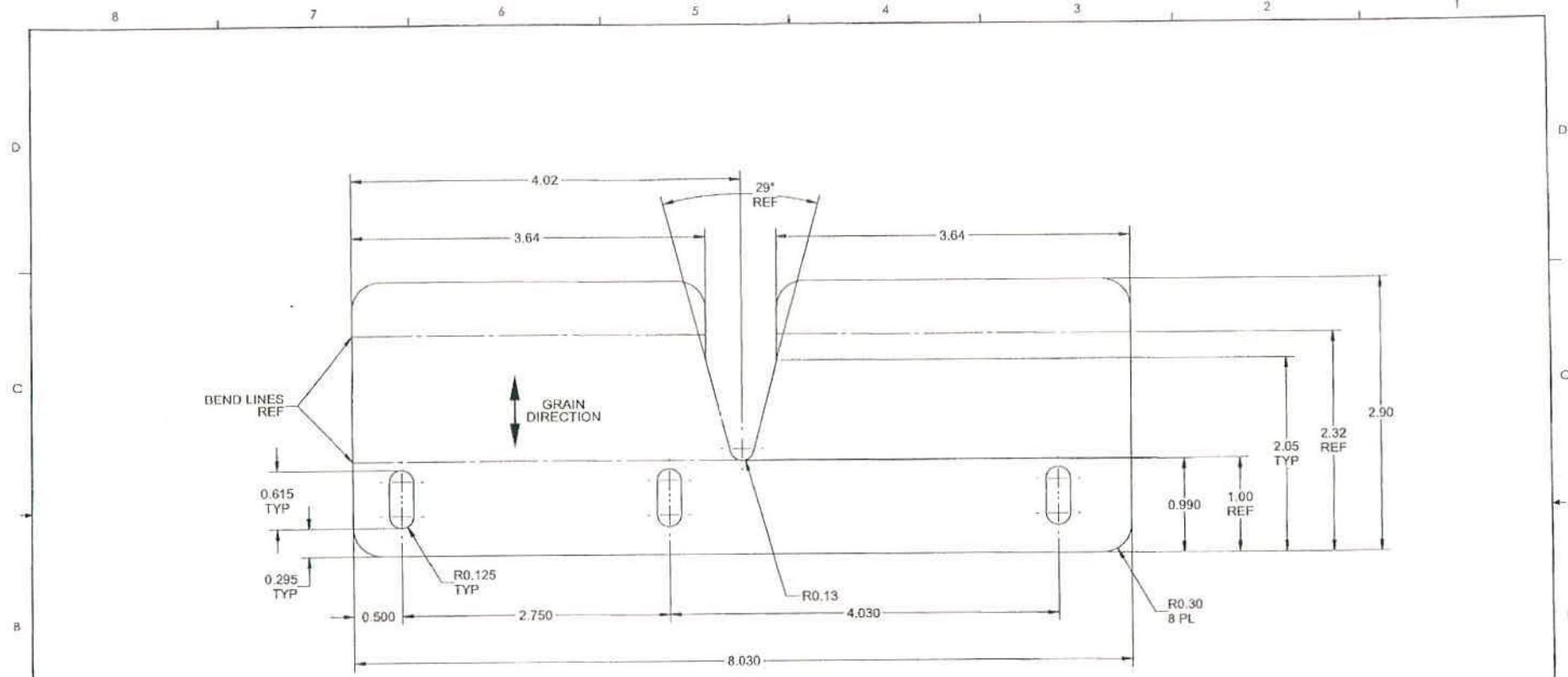
D3199-4 BRACKET  
MADE FROM D3199-3F



RELEASED  
2011-07-18  
MM

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. E
MFG. APPR.	<i>[Signature]</i>	D3199 SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	BRACKET NTS
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75206



D3199-3F FLAT PATTERN

RELEASED  
2011-07-18  
JW

## NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH  
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.25 lbs

8 1 7 1 6 1 5 1 4 1 3 1 2 1 1

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	REV. E
MFG. APPR.	<i>[Signature]</i>	D3199 SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE
DE APPR.	<i>[Signature]</i>	SCALE
DATE	11.07.11	NTS

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DART AEROSPACE LTD

Work Order: 15206

Description: BLACK

Part Number: D3144-3

Inspection Dwg: 13194-3 Rev:

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

First Article       Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.64 +L -.30	.30	3.330	X		V	
4.02 +L -.22	.22	4.022	?			
2.90 +L -.02	.02	2.904	C			
1.000 +L -.00	.00	1.003	?			
.614 +L -.00	.00	.613	?			
.795 +L -.00	.00	.794	?			
.500 +L -.00	.00	.501	?			
2.756 +L -.00	.00	2.754	?			
4.030 +L -.00	.00	4.033	?			
8.030 +L -.00	.00	8.039	?			
.407 +L -.00	.00	.044	?			

Measured by: G

Audited by:

#### Prototype Approval:

Date: 1-17-09

Date: 11/10/05

Date:

Rev	Date	Change
A		New issue

Revised by      Approved  
KJULM